

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021187**Date Inspected:** 16-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhong Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

OBG Segment 9BW

During in process visual inspection of 9BW-9CW, This QA Inspector observed ZPMC personnel performing Heat Straightening on 9BW LD # SEG051B as per HSR report # HSR1(B)-8698 dt 27th June 2010. ZPMC Quality Control (QC) is identified as Xu Jin Long.

OBG Segment 9BW-9CW

Shielded Metal Arc Welding (SMAW) in the 4G position of 9BW-9CW Cross beam side Edge Panel splice weld joint. Weld # OBW9-010. The welder is identified as 066326. ZPMC Quality Control (QC) is identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1. See attached photograph Pic_001.

OBG Segment 9CW

During in process visual inspection of 9CW, This QA Inspector observed ZPMC personnel performing Bottom

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Panel Edge Bevel preparation connecting to 9DW. ZPMC Quality Control (QC) is identified as Xu Jin Long. See attached photograph Pic_002.

OBG Segment 9BW-9CW

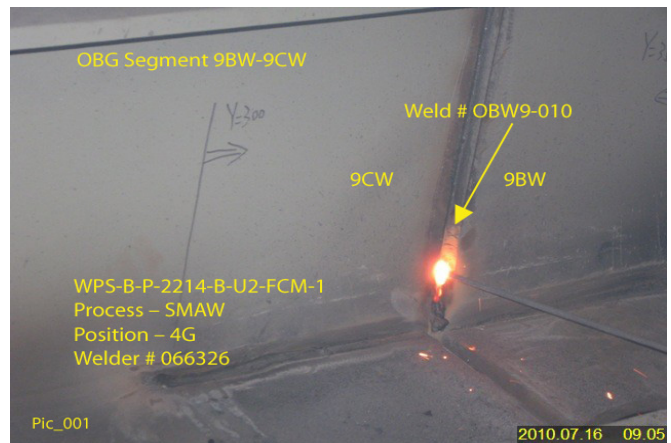
Shielded Metal Arc Welding (SMAW) in the 4G position of 9BW-9CW Counterweight side Edge Panel splice weld joint. Weld # OBW9-006. The welder is identified as 045196. ZPMC Quality Control (QC) is identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

OBG Segment 9BE-9CE

During in process visual inspection of 9BE-9CE, This QA Inspector observed ABF Quality Assurance (QA) personnel performing Magnetic Particle Testing (MT) on Deck Panel Splice weld. ABF QA personnel identified as You Yi Lin.

OBG Segment 9BW-FL3

Flux Core Arc Welding (FCAW) in the 2G position of 9BW-FL3 Half diaphragm web to bottom weld. Weld # SSD25-PP075-67. The welder is identified as 207465. ZPMC Quality Control (QC) is identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-FCM-1.



Summary of Conversations:

No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

Inspected By: Gade,Ramesh

Quality Assurance Inspector

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Reviewed By: McClendon, Timothy

QA Reviewer